

Date: Wednesday, 07/01/2009 1:38:26 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS STEP LH (FOLDING)
Job Number : 44488	
Estimate Number : 12567	
P.O. Number :	Part Number : D412630033
This Issue : 07/01/2009 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : L
Previous Run : 41646	Material :
Written By :	Due Date : 02/02/2009 Qty: 3 Um: Each
Checked & Approved By : <u>JLD 09.01.09</u>	
Comment : Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Approved 09/01/26

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

2.0

D2012107

Clevis

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

B40274

SP 09/01/21
2X 345074 (12)

3.0

D2803041

Bracket Assembly

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

D41672

SP

4.0

D2804041

Bracket Assembly

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

D41674

9/1/21

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44488

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Support Prop
Batch: 43901

sq

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Washer
Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

B41667

sq

7.0

D3562041

Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Step Weldment LH
Pick:

Qty	Part Number	Description
1	D3562-041	Step Weldment LH

Batch

B43512

EP. 09/01/22

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Bushing
Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

B41669

42100

sq

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
BOLT
Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

M101189

9/1/21

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M102736

SP

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M106431

①
S
M109148

SP

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763

①
⑤
M109148

SP

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M109268

SP

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M108964

9/1/21

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M109099

SP

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M110023

SP

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

9/1/21

SP

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON

BATCH:

M104255

EB09/01/26(3)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/16/26 43LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0 D28061 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	

B4274 x1
B39057 x5

SS 09/01/26 (X3)

22.0 D28063 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	

B39058 x3
B4275 x3

SS 09/01/26 (X3)

23.0 D28105 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	

B41676

SS 09/01/26 (X3)

24.0 D33961 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	

B41670

SS 09/01/26 (X3)

25.0 AN4C6A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch

M109147

SS 09/01/26 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 44488

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	AN4C6A	Bolt
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26.0	AN4C10A	Bolt
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

M104679

AS 09/01/2009 (X3)

27.0	AN4C15A	Bolt
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

M167080

AS 09/01/2009 (X3)

28.0	AN44C7A	Eyebolt
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN44-C7A	Eyebolt

Batch

M160446

AS 09/01/2009 (X3)

29.0	AN5C15A	Bolt
------	---------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

M105125

AS 09/01/2009 (X3)

30.0	NAS1515H4	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H4	Washer

Batch

M109267

AS 09/01/2009 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 44488

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	

M109430 x7

M108334 x14

SS 09/01/2009

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	

M109106

SS 09/01/2009

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	

M109535

SS 09/01/2009

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

kit already pkged & checked per

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

A 09/01/2009

36.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/2009

Job Completion



MF 09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

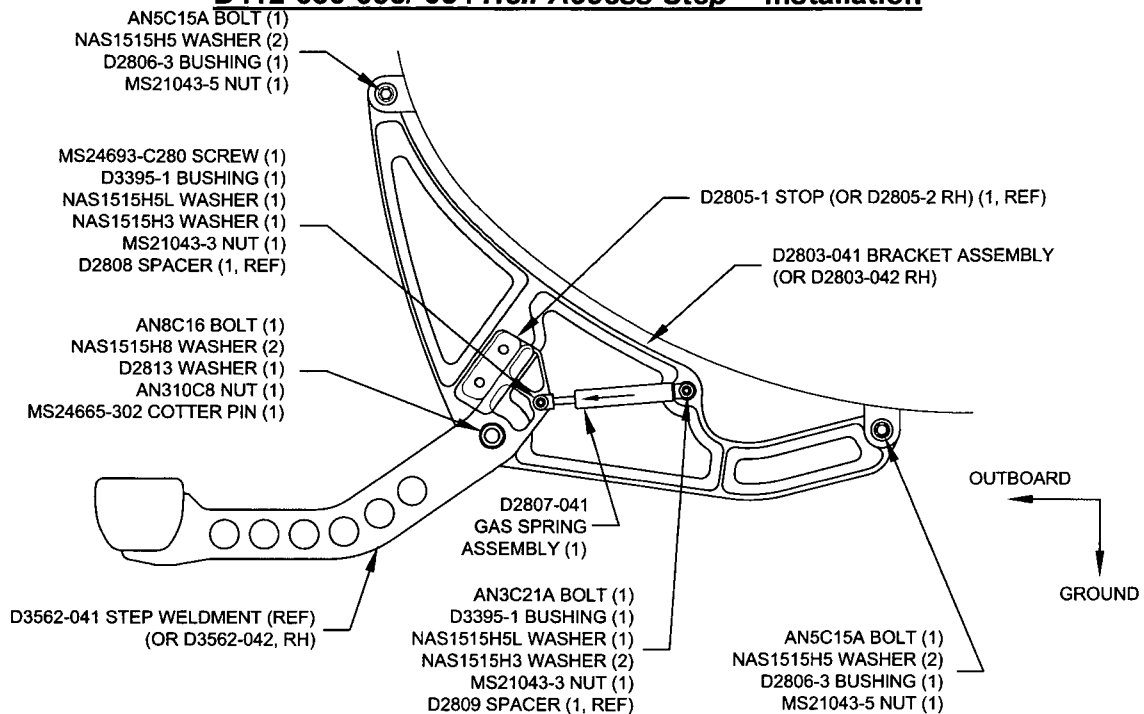
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

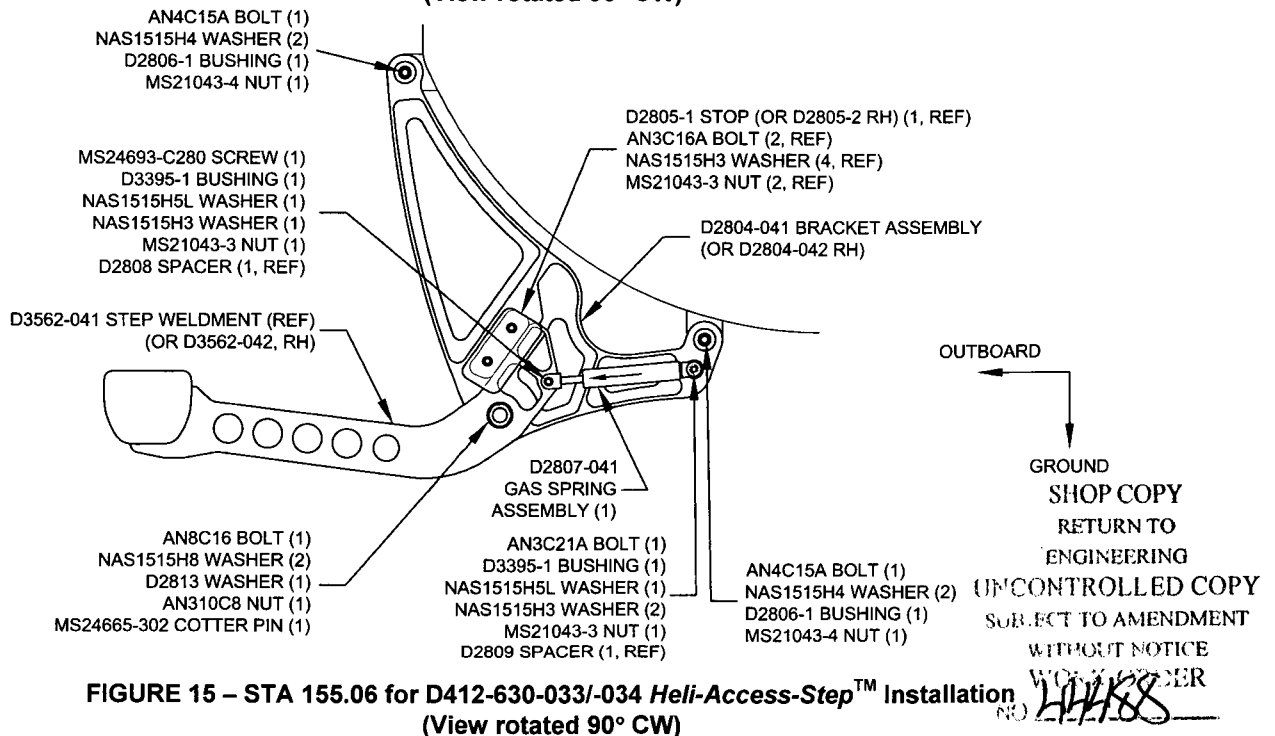


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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Revision: L
Date: 07.09.30

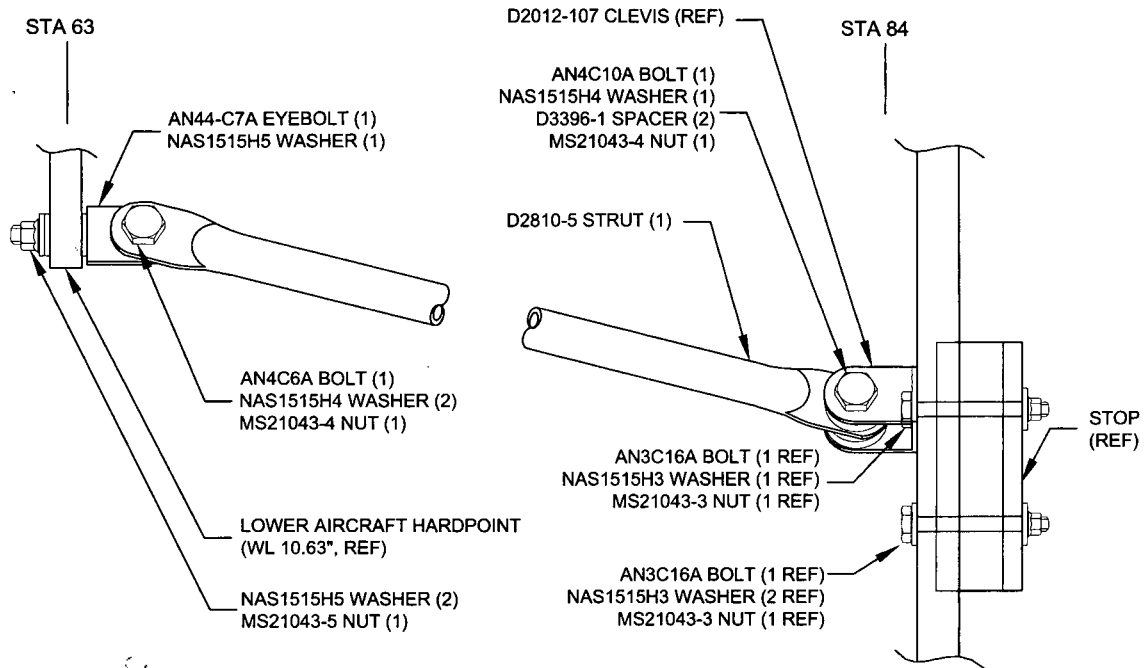


FIGURE 16 – Strut Detail for D412-630-033/-034 Heli-Access-Step™ Installation
(NOT TO SCALE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14488